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PRELIMINARY ISSUE

651.0111

Job Sheet 210877



Part No: 651.0111

Job Qty: 3 pcs

Part Name: 45° Elbow



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/9/20

Description:

Type: SOLD

Note: 651.0100 REV.PE2 IPP REV:A 20.06.23 NEW ISSUE DD VERF:JFS

Ship Via:

AW 139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Mill - 1	3 pcs	7/9/20	7/9/20	0.25	0.40	Conventional Mill - 1		
							Conventional Mill - 2		
120	QC 2	3 pcs	7/9/20	7/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S288631



Part: 651.0111

Job No: 210877

Serial No/Batch: S288631

Revision: REV.PE2

Inspector:

Exp Date:

Instructions:

Date: 07/1/20

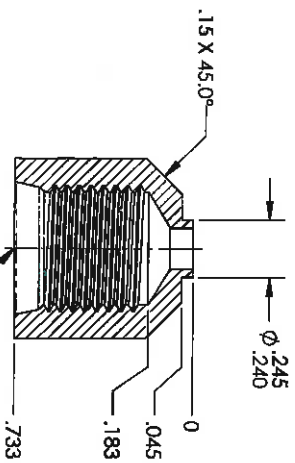
Amal / P21 WA

130	QC 8	3 pcs	7/9/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
180	Packaging 3-1 - Stock - B4B	3 pcs	7/9/20	0.00 0.00	QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

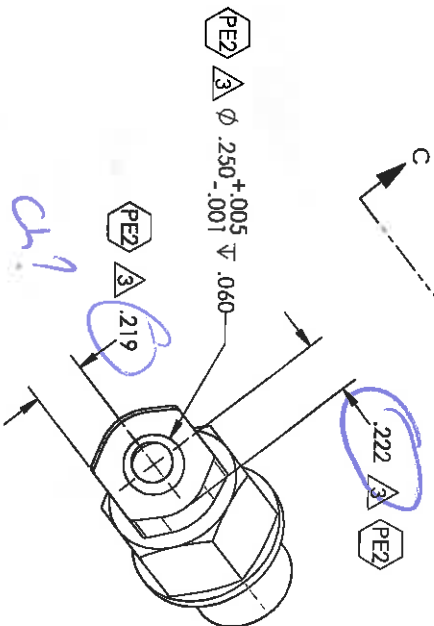
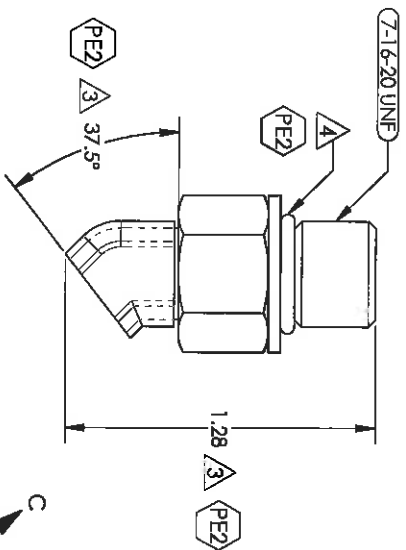
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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				190 QC 21 - SA	3 pcs
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
Part Op 110 - MODIFY AS PER DWG AND DEBURR Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 180 - Identify as per dwg & Stock 190 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
601.3846	45 Degree Elbow	3 pcs (1 ea)	110-Conventional Mill - 1	5295289	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Conventional Mill - 1	601.3846	3	0	0	
Part Specifications					
Specifications could not be found.					

Plex 6/25/20 8:47 AM Dart.Renwick.Jennifer



—PORT PER SAE J1926-5
UNLESS OTHERWISE SPECIFIED



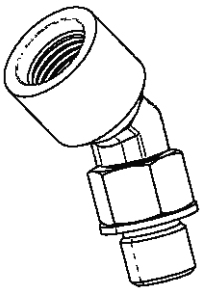
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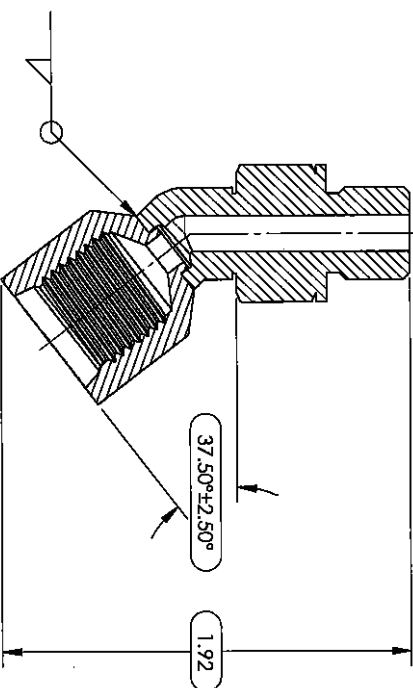
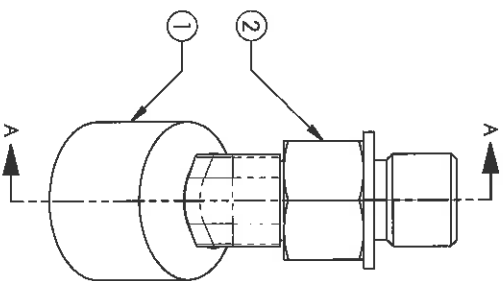
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NOTES: **PE2**

- 1 MATERIAL: STAINLESS STEEL 316 IAW ASTM A276
- 2 MATERIAL: 601.3846 45 DEGREE ELBOW
- 3 FEATURE ADDED FROM 601.3846 45 DEGREE ELBOW SOURCE CONTROL DRAWING
- 4 DISCARD O-RING INCLUDED WITH 601.3846 45 DEGREE ELBOW DRAWING
- 5 WELDS IAW AWS-D17.1 CLASS C TIG WELD WITH ER308L OR ER316L FILLER ROD
- 6 DEBURR AND BREAK ALL SHARP EDGES
- 7 FINISH: IAW MPP-172 PASSIVATE IAW SECTION 6.1
- 8 IDENTIFY IAW MPP-120



651.0101



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 210827

REV	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE	07/29/15	P. BLAYO
A	INCORPORATED ECU 0803	07/29/15	P. BLAYO
B	INCORPORATED ECU 0803	07/29/15	P. BLAYO
C	INCORPORATED ECU 0803	08/12/15	P. BLAYO
D	INCORPORATED ECU 0803	08/17/15	P. BLAYO
E	INCORPORATED ECU 0803	08/27/15	P. BLAYO

ZONE	REV	DESCRIPTION	DATE	APPROVED
A-1-1	1	NOTE 1: ADDED ASTM A276 STANDARD, NOTE 3: ADDED ER308L FILLER ROD, NOTE 4: ADDED SECTION A-A, NOTE 5: ADDED DIMENSION 1.92	05/28/2020	T. CROSS
B-1-1	1	MODIFIED WELDING SYMBOL LOCATION		
D-1-1	1	ADDED SECTION A-A		
D-3-2	1	MODIFIED PORT C-OUT		
C-5-2	1	MODIFIED HOLE DIMENSION		
C-6-2	1	ADDED DIMENSION		
B-7-2	1	ADDED DIMENSION		
A-1-1	1	UPDATED BOM		
A-5-2	1	ADDED FLAG NOTE 4		
A-6-2	1	FLAG NOTE WAS 2 IS 3		
B-6-2	1	FLAG NOTE WAS 2 IS 3		
C-5-2	1	P/N WAS 601.3846 IS 651.0111		
C-6-2	1	FLAG NOTE WAS 2 IS 3		
C-7-2	1	FLAG NOTE WAS 2 IS 3		

QTY	REV	DESCRIPTION	DATE	APPROVED
1	1	651.0111	45 DEGREE ELBOW	Δ/Δ
1	1	651.0110	GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ
1	1	651.0101	ANGLED GAUGE ADAPTER	Δ/Δ

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SCALE NONE
SHEET 1 OF 2



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>210 877</u>		DEPARTMENT/PROCESS	
Part No. <u>6510144-110</u>		Eng. (Non-AW)	
Date: <u>20/07/17</u>		Prod. Eng. Coord.	
Sequence #: <u>110</u>		Rec/Store/Packaging	
Disposition		Engineering	
Rework		Water Jet	
Scrap		Supplier	
Use-as-is		Quality	
QTY Affected: <u>2</u>		MRB (QSI042)	
Description Work Order Deviation		DAS <u>51 20/07/17</u>	
Miss read drawing, Angle wrong		Completed By <u>20/07/17</u>	
Side		Lead hand / Supervisor <u>De 20-07-17</u>	
Disposition		QC / QA Coordinator	
Scrap + destroyed			
Root Cause		FAULT CATEGORY	
Operator ☒		Positioned Wrong	
Manufacturing Process		Outside Tolerance	
Equip/Tooling		Drawing	
Handling/Preservation		Finish	
Material		Part Lost/Missing	
Product Improvement		Misread	
Process Improvement			
Human Factors			
Pressure/Forced		Power Loss/Surge	
Bending		Folio/Program	
Crushing		Grain Direction	
Cracks		Weld	
Crimp/Kink/Ripple/Wave/Twist		Wrong Stock Pulled	
Marks/Chatter		Out of Sequence	
Mislabeled		Off-set/Set-up	
Other/Details:			

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: <u>210977</u>		DISPOSITION		DEPARTMENT/PROCESS		Completed By	
Part No. <u>651.0100</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		MRB (QS1042) DAS 51 20/7/17 9.80	
Date: _____		Sequence #: _____		QTY Affected: _____		Lead hand / Supervisor	
Description Work Order Deviation		Disposition		QC / QA Coordinator		B. 20-07-17	
Ø230 hole need to be on center, to start avoid the two .222 + .219 Dia's tolerances and use them as Ref only.		Acceptable					
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐	
Product Improvement ☒		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐	
Human Factors ☐		Other/Details: _____				Positioned Wrong ☐	
						Outside Tolerance ☐	
						Drawing ☒	
						Part Lost/Missing ☐	
						Misread ☐	

